



Dart Aerospace Ltd.
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Canada

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D4776-5

Job Sheet 197674



Part No: D4776-5

Job Qty: 139 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Due Date: 8/19/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D4776 REV:E IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS PER
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	139 pcs	8/19/19	8/19/19	0.05	7.76	Doosan - 1		19/08/15
120	QC 8	139 pcs	8/19/19	8/19/19	0.00	0.00	QC 8 - 12		19-08-15
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	139 pcs	8/19/19	8/19/19	0.00	0.68	Handfinish - 1 - 1 - B4B		AUG 16 2019
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		

DAS
65
9-89

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					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	139 pcs	8/19/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
150 Packaging 3-1 - Stock - B4B	139 pcs	8/19/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 -	

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40
AUG 16 2019 9:59

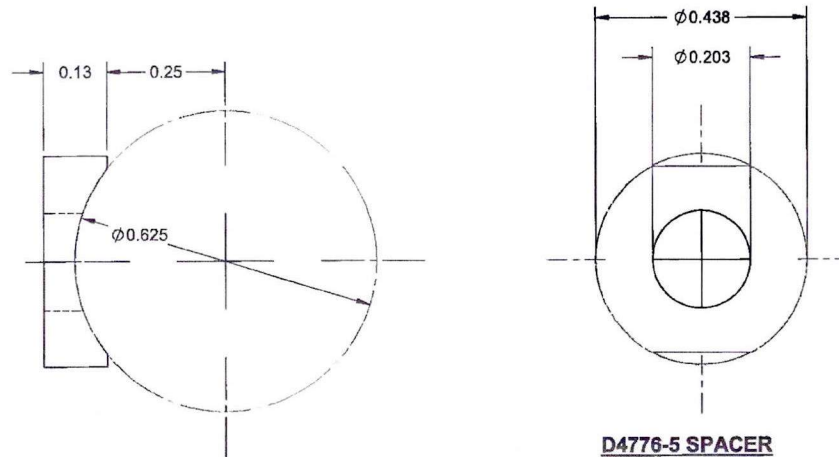
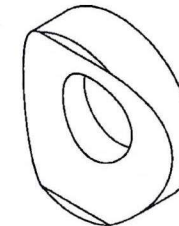
				B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST115
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
160 QC 21 - SA	139 pcs	8/19/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	70
				QC 21 - SA - 53	53
Part Op 100 - Doosan (Doosan Lathe) 1-Turn as per Folio and Dwg Dwg rev: <u>E</u> Folio rev: <u>AA</u> Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 140 - (QC7-Inspect Chemical Conversion Coat) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R0.500	6061-T6 Round Bar .500"	2.7800 ft (.02 ea)	100-Doosan - 1	5046379	1458
				5006798	174
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M6061T6R0.500	3	33	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches $\pm$ 0.030	0.160 0.100		
2	Spacer	0.250Inches $\pm$ 0.030	0.280 0.220		
3	Spacer	0.625Inches $\pm$ 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches $\pm$ 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

197674



D4776-5 SPACER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4776-5" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

RELEASED
2018-12-03
ECN 18-804

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4776	REV. E SHEET 3 OF 3
MFG. APPR.	JFS	TITLE	SCALE
APPROVED	VS	BASKET STRUT MACHINED PARTS	
DE APPR.	DSW	NTS	
DATE	18.09.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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Container No: S206111



Part: D4776-5

Job No: 197674

Serial No/Batch: S206111

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/15/19